

Date: Wednesday, 03/09/2008 10:35:13 AM
User: Julie Leppin

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE ASSEMBLY
Job Number : 41767B -2
Estimate Number : 11180
P.O. Number :
This Issue : 03/09/2008 S.O. No. :
Prsht Rev. : NC
First Issue : // Type : SMALL /MED FAB
Previous Run : 41173B
Part Number : D2282043
Drawing Number : D2282 REV E
Project Number : N/A
Drawing Revision : E
Material :
Due Date : 30/10/2008 Qty: 100 Um: Each
Written By :
Checked & Approved By : JLD 089.03
Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2281 Jack Saddle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2281 Saddle B41888 → 53x
B39817 → 47x

2.0 D22827 Tube



Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s) B41891 → 99x

Pick:

Qty Part Number Description Batch
2 D2282-7 tube B39818 → 34x
B35474 → 67x

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

A/R ER316L SS Filling Rod M105775
Dwg Rev: E

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush, take all welding marks out and deburr holes

SAD 08/10/21 100

Date: Wednesday, 03/09/2008 10:35:13 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 41767B

Part Number: D2282043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/10/22

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/22 (X100)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-tumble

B 8-11-3

(50)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/04

(X100)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

08/11/04 (50)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/05

Job Completion



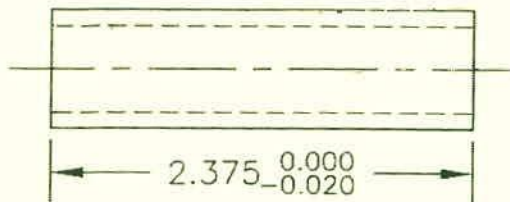
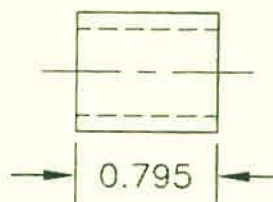
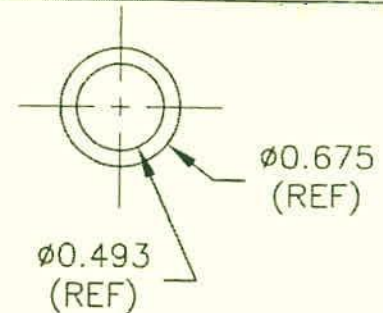
MF 08-11-04

DART

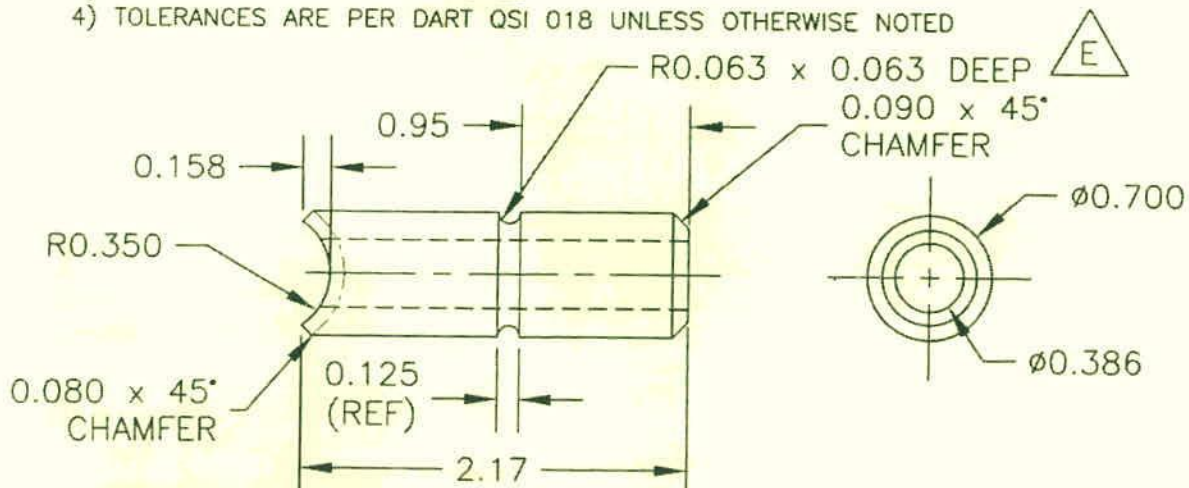
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

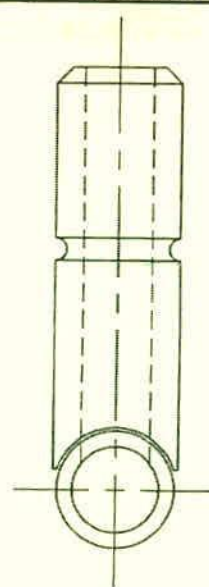
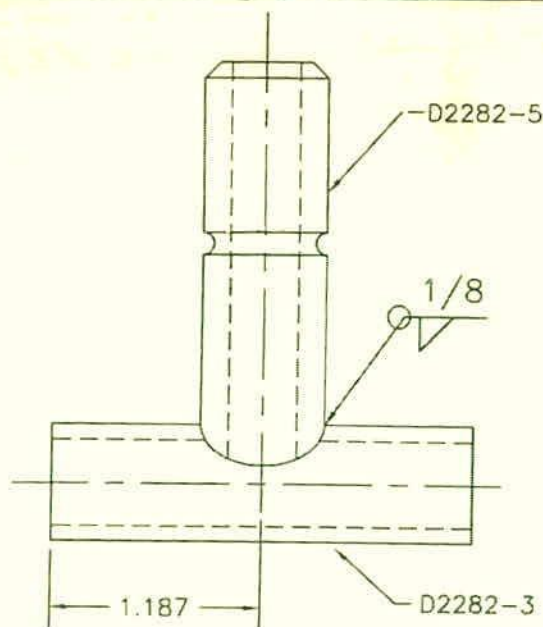
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *4767B*

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

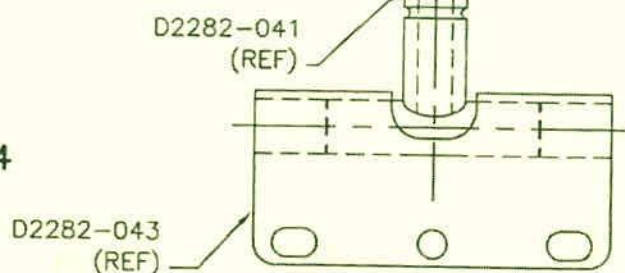
DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

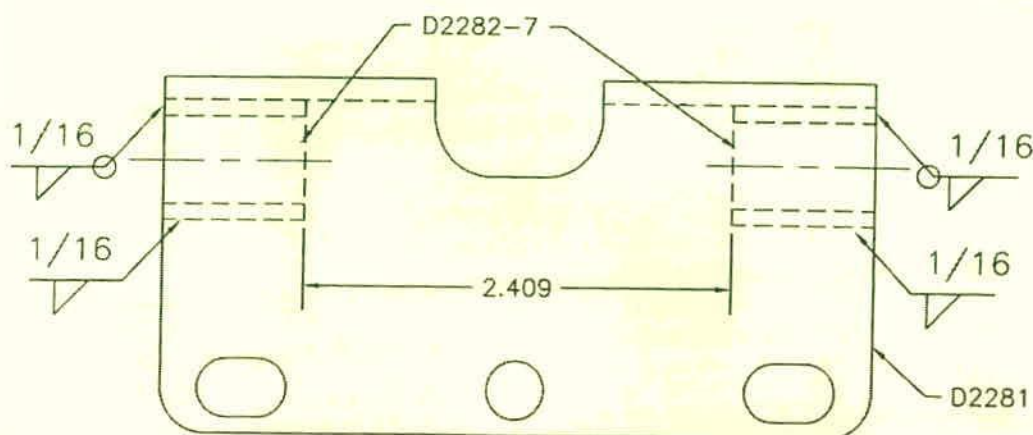


RELEASED
[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *41767B*

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

